











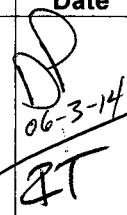
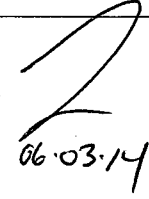
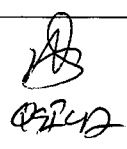

Date: Monday, 2/27/2006 4:18:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001: Dart Helicopters Services	Drawing Name	: 206 A/B HIGH GEAR WEB
Job Number	: 25979	Part Number	: D26543
Estimate Number	: 10455	Drawing Number	: D2654 REV E1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/27/2006 S.O. No.: N/A	Drawing Revision	: E1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type: LANDING GEAR	Due Date	: 3/20/2006 Qty: 4 Um: Each
Previous Run	: 25913		
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: 06.02.28		
Comment	: Est Rev:D 06.02.04 Fixed typo, Changed procedure DM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description:	
1.0	D26005108	Extrusion 'I Beam' thin	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)			
	Pick:		
	Qty	Part Number	Description Batch
	1	D2600-5	Web 324410
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1			
1-Cut D2600-5 to length as per Dwg D2654 RT 06-03-13 (4)			
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 RT 06-03-13 (4)			
3-Using the uni-bit, open holes to finish size as per Dwg D2654 RT 06-03-13 (4)			
4-Deburr holes and ends RT 06-03-13 (4)			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP DP 06-3-14 (4)			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1			
Chemical Conversion Coat as per QSI 005 4.1 FC 06 03 16 (4)			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-14	2	5 webs scrap. were cut and drilled to 02600-5 dwg. Employee looked at wrong dwg. - 5 referred to type of web to use.		Scrap and destroy webs. replace. Retrain employee	 06-3-14 BT	 06-03-14		 06-03-14

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:18:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 25979

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-03-20 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L/G

BE 06-03-20 (4)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/21 (4)

Job Completion



U 06.03.21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

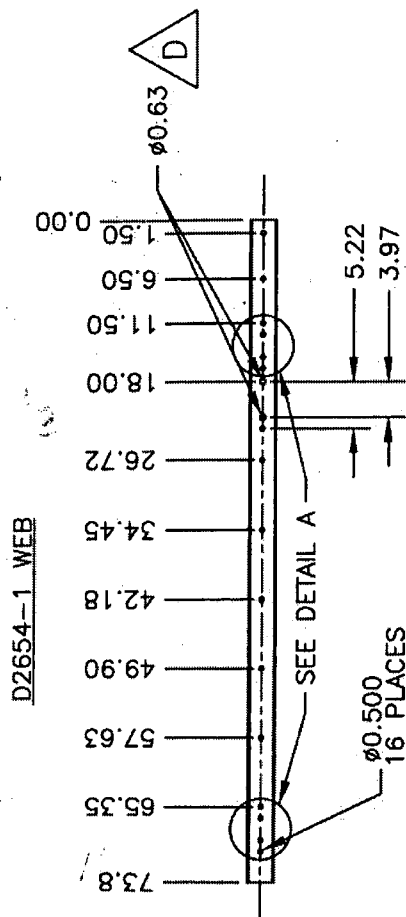
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

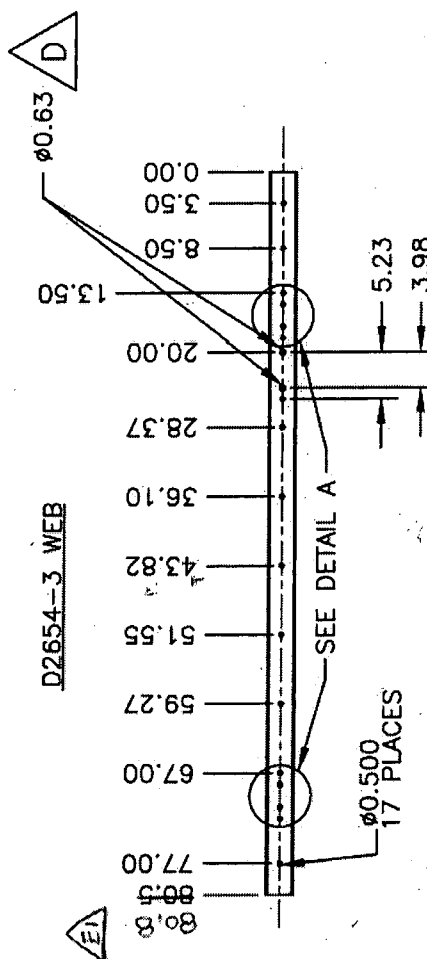
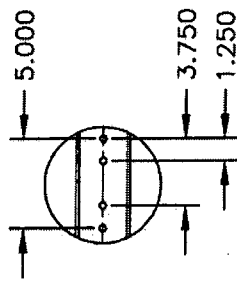


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP #</i>	04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



DETAIL A
SCALE 1:10

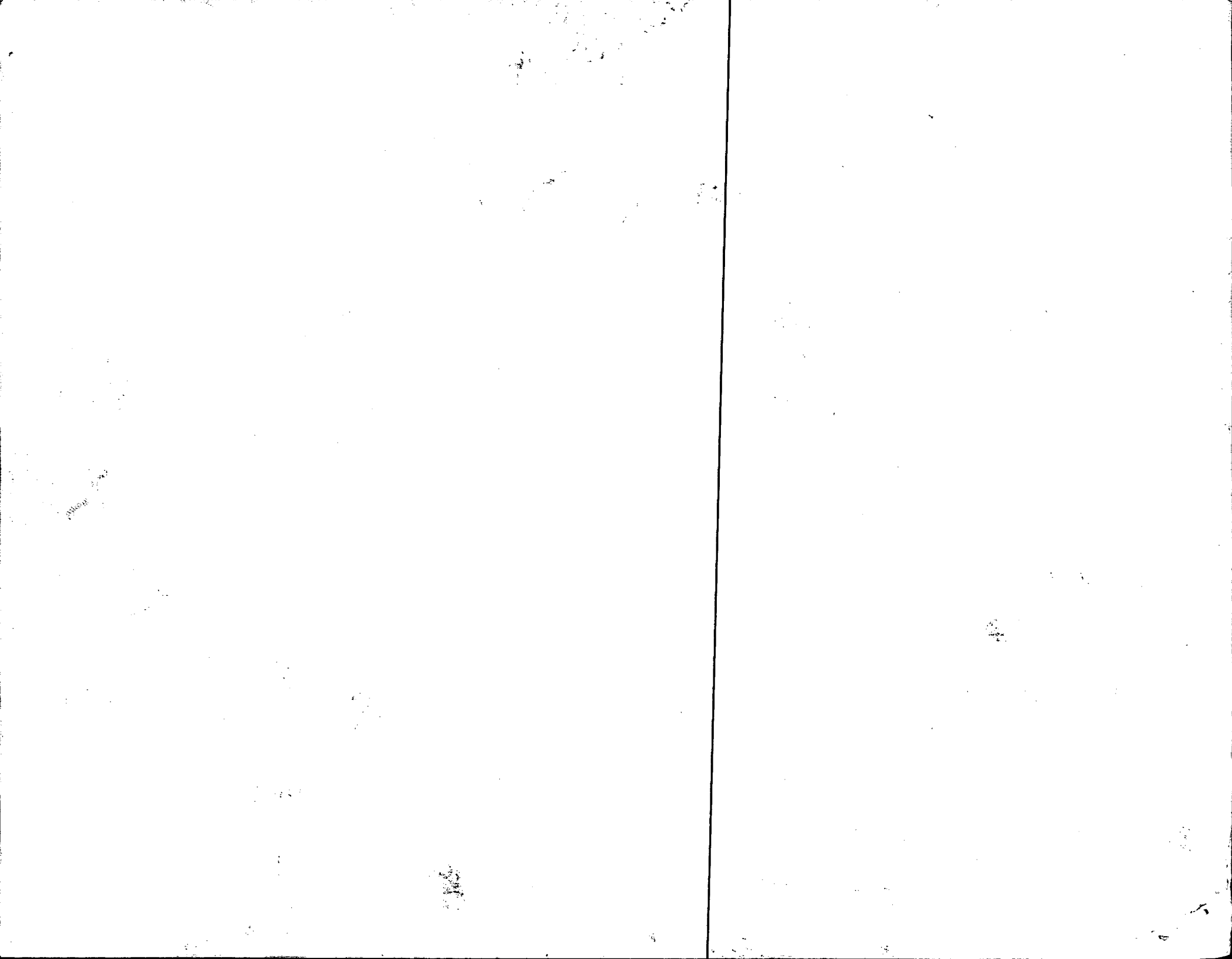


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WORK ORDER
NO. 25979

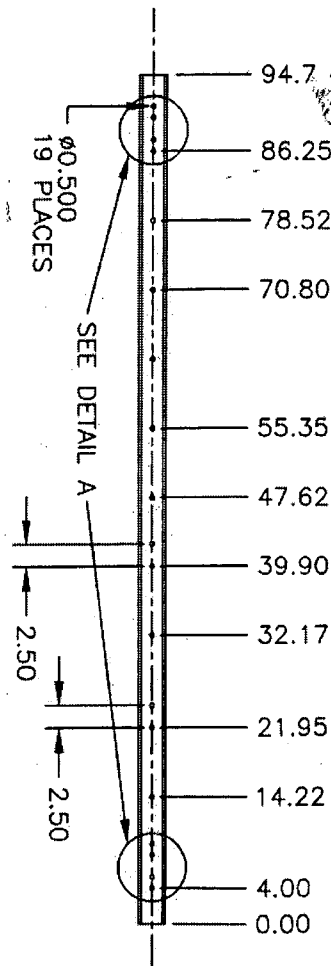
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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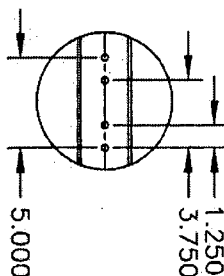
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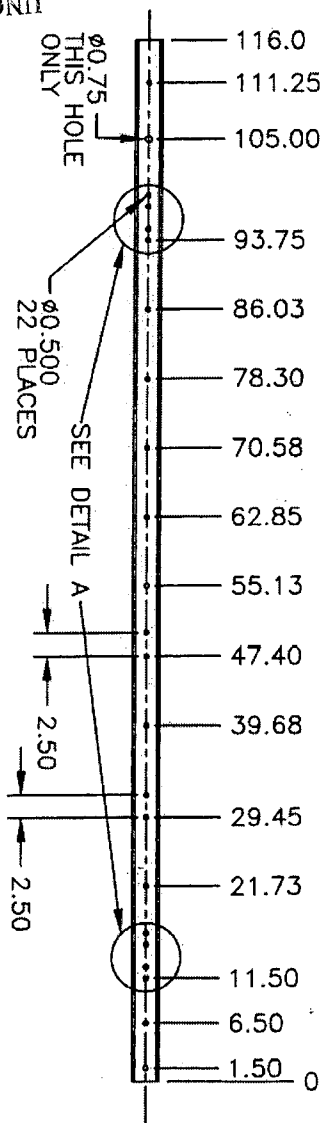
D2654-5 WEB



DETAIL A
 SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
 FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
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 WITHOUT NOTICE
 WORK ORDER NO. 259279

RELEASED
 04.05.26

DART



DESIGN BY	APPROVED	DATE	04.05.26
DRAWN BY	APPROVED	TITLE	WEB
DART Aerospace USA, INC. PORT HADLOCK, WA	D2654	SCALE	1:20
REV. E	SHEET 2 OF 2		

